

# Work Order ID 70461

Thursday, June 09, 2011 7:40:59 AM



Page 1

Item ID: D3535-21

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 6/9/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/13/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-06-9

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Deburr if necessary

304 . 040

B11-6-10

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-6-10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8 w/06/13

(X6)

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Page 2

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Setup Start



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Stop



Item Name: Wearshoe

Start Date: 6/9/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/13/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Form bend &amp; joggle as per Dwg D3535 using DT8261 &amp; DT8326

8/11/06/14

6

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/11/06/14

8/11/06/14

150

0.00



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

12:15

11:45

320 °F

6x Ø M 7/11/06/14

M 11/5128

**Work Order ID 70461**

Thursday, June 09, 2011 7:40:59 AM

Page 3

Item ID: D3535-21

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearshoe

Start Date: 6/9/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 6/13/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: F-P18 0.00

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

6x Ø m-d 11/06/14

11/6/15

MF 11-06-14

# Picklist Print

Thursday, June 09, 2011 7:40:57 AM

Page 1

Work Order ID: 70461

Parent Item: D3535-21

Parent Item Name: Wearshoe



Start Date: 6/9/2011

Required Date: 6/13/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA

Purchased

No

100

sf

249.9814

0.8925

5.636842



304/316 .040 Sheet



B11-610

Location

Loc Qty

Loc Code

MAT020

249.9814

116623

0.2

117550

10.1814

117933

239.6

117933

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	7046
<b>Description:</b> Wearshoe		<b>Part Number:</b>	D3535-21
<b>Inspection Dwg:</b> D3535 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article    ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.192	X		V HB62	
2.000	+/-0.010	2.006	X		V	
2.000	+/-0.010	2.000	X		V	
1.885	+/-0.010	1.888	Ø		V	
0.300	+/-0.010	.304	X		V	
0.300	+/-0.010	.306	X		V	
5.450	+/-0.010	5.456	X		T HB01	
10.900	+/-0.010	10.900	X		T	
16.350	+/-0.010	16.356	X		T	
21.800	+/-0.010	21.800	X		T	
27.250	+/-0.010	27.256	X		T	
32.700	+/-0.010	32.700	X		T	
6.00	+/-0.030	6.00	X		T	
8.00	+/-0.030	8.00	X		T	
16.00	+/-0.030	16.00	Ø		T	
24.00	+/-0.030	24.00	S		T	
0.040	+/-0.010	.036	X		V	

<b>Measured by:</b>	RB
<b>Date:</b>	11-6-16

<b>Audited by:</b>	Ø
<b>Date:</b>	11/06/13

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	10.2.02	New Issue	KJ	Ø

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

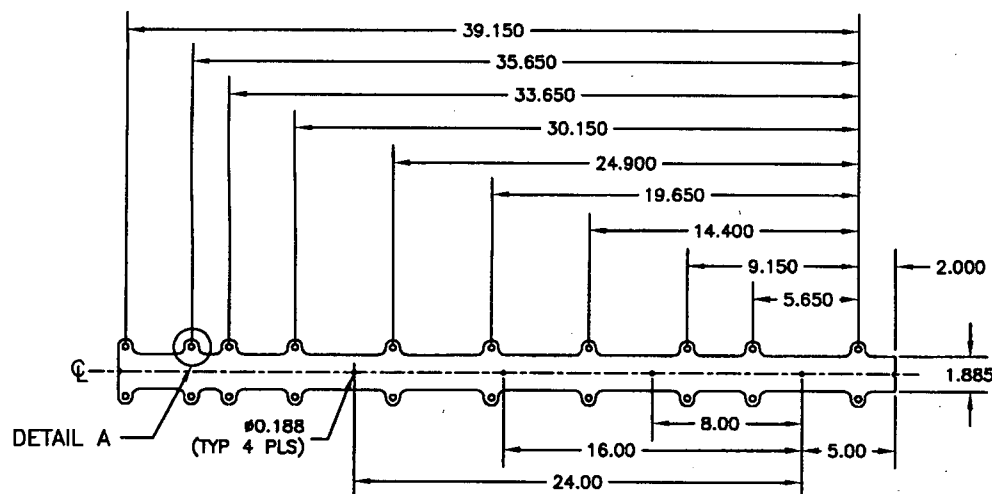
RELEASED

07.04.17

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	SHEET 2 OF 7
07.04.17	WEARSHOE	SCALE
		1:10

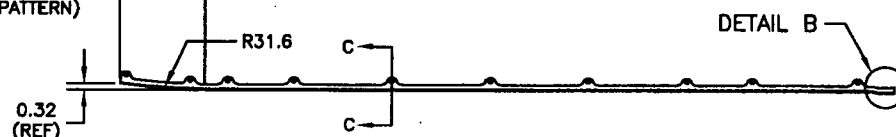
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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70461

PH 11-26-9

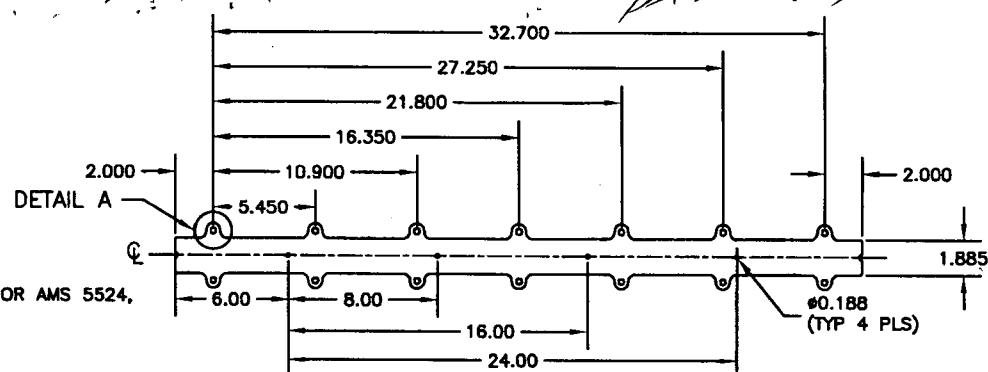


4.50 TO BEND  
LINE (ON FLAT  
PATTERN)

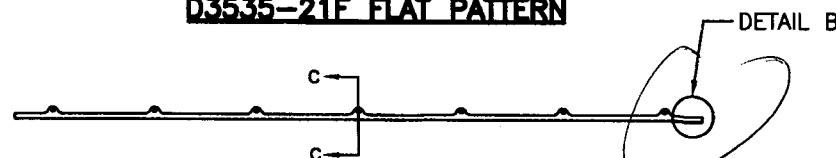
**D3535-15F FLAT PATTERN**



**D3535-15 BEND DETAIL**



**D3535-21F FLAT PATTERN**



**D3535-21 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

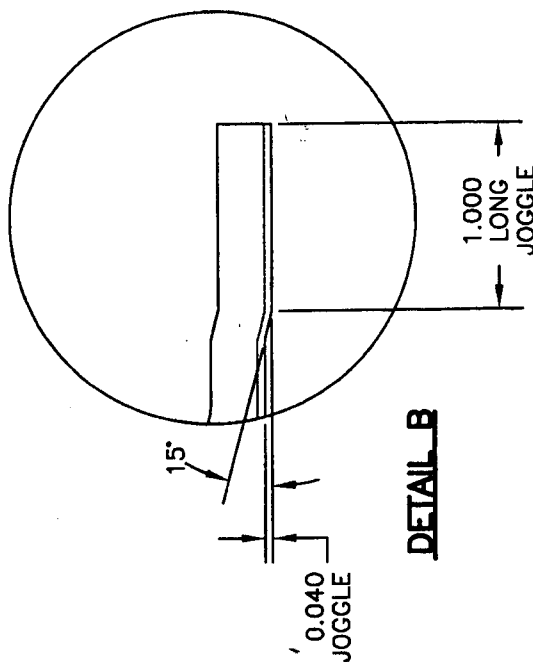
**NOTE:** Date & initial all entries



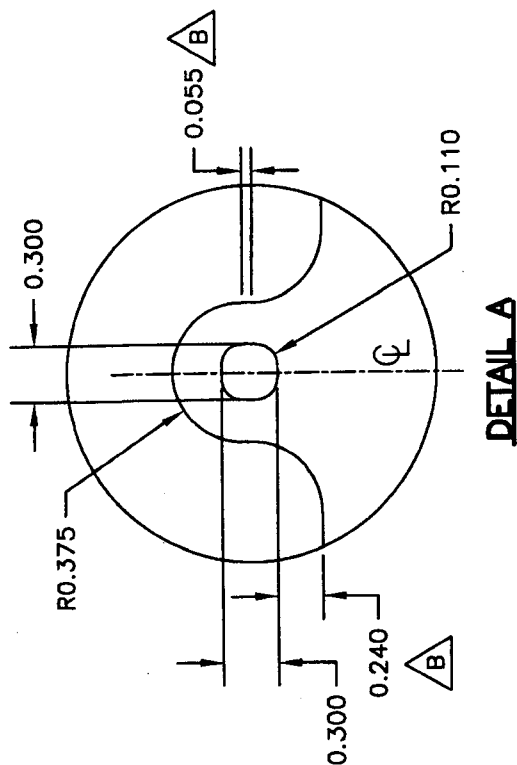


DESIGN <b>CB</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

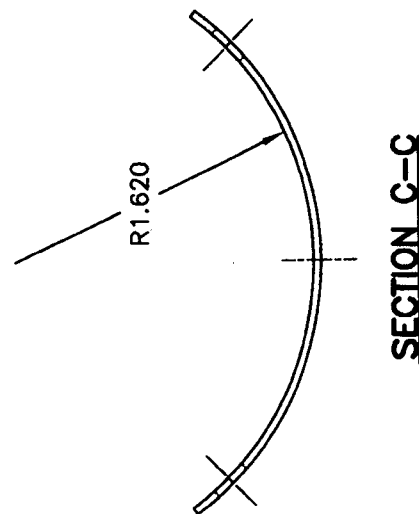
RELEASED  
07.04.24 *[Signature]*



**DETAIL B**



**DETAIL A**



**SECTION C-C**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries